

Date: Wednesday, 3/22/2006 8:47:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26314
 Estimate Number : 11421
 P.O. Number : N/A
 This Issue : 3/22/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 25214

Drawing Name : PLATE
 Part Number : D34617
 Drawing Number : D3461 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 3/29/2006

Written By : SEE COMMENT BELOW
 Checked & Approved By : [Signature]
 Comment : est. REV. A 05.12.13 NEW ISSUE EC

Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0187X04000 6061-T6 Bar .178" x 4.0"



Comment: Qty.: 0.4064 f(s)/Unit Total : 4.0635 f(s)
 ALUMINUM 6061-T6 Bar .188" x 4.0"
 Batch: M19524

J.L 06-03-24

2.0 SHEAR SHEAR



Comment: SHEAR
 cut blanks 4.660" long +0.03" -0.01"

J.L 06-03-24 6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per folio FA610 rev: AA & dwg D3461 rev. A

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06-03-24 12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 06/03/24 12

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr parts per dwg D3461

J.L 06/03/24 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/03/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/22/2006 8:47:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 26314

Part Number: D34617

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W 06.03.24

12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA25*

P.L. 06.03.24

12

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

SD 06/03/27 (12)

Job Completion



W 06.03.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

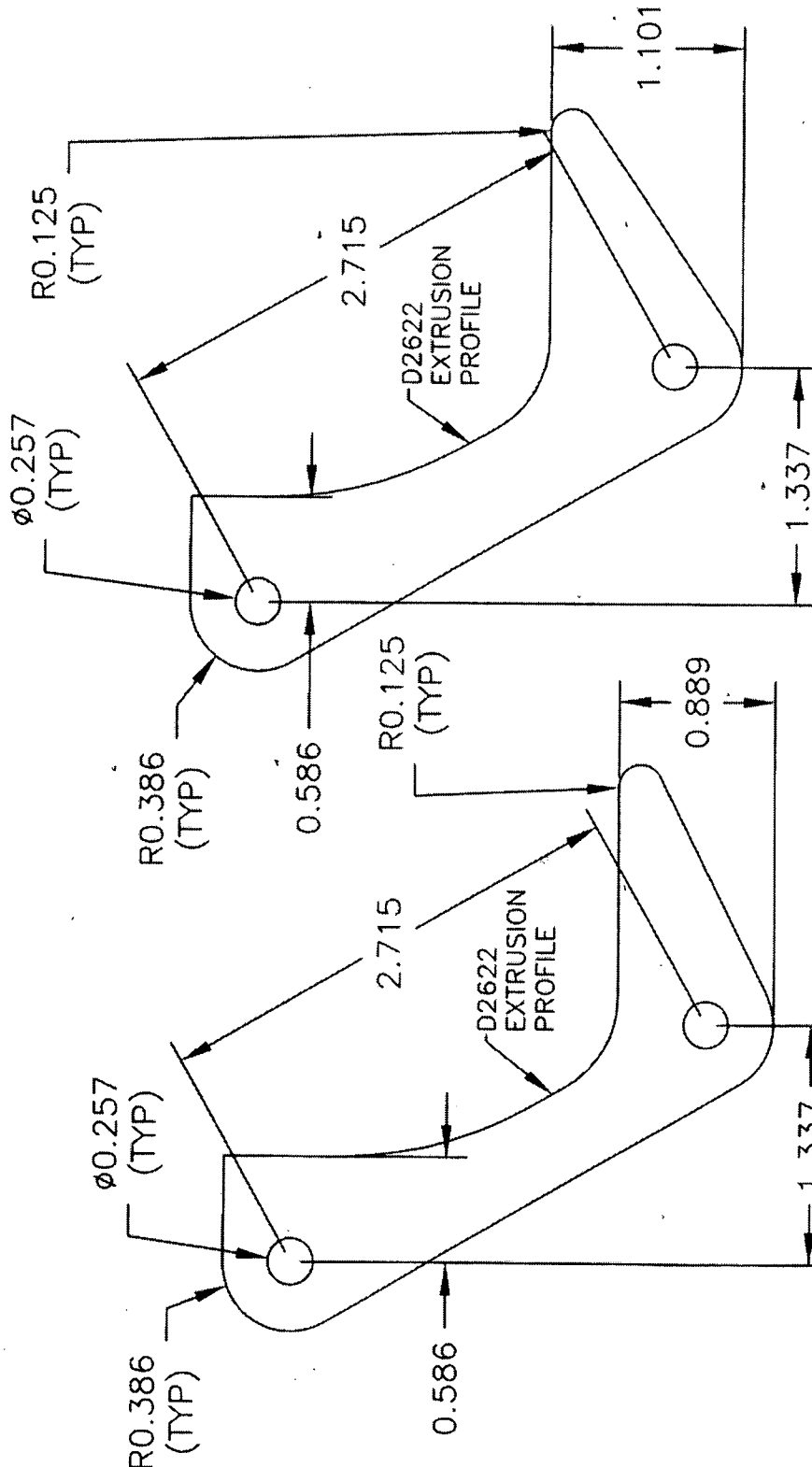
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3461	REV. A SHEET 2 OF 2
DATE 05.09.19	TITLE STEP MOUNTING PLATE		SCALE 1:1



D3461-5 MOUNTING PLATE

D3461-7 MOUNTING PLATE

RELEASED

05-11-14

D3461-5/-7 MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	26314
Description: plate		Part Number:	D 3461-7
Inspection Dwg: D3461	Rev: A	Page 1 of 1.	

Part Number: D 3461-7

Description: plate

Inspection Dwg: 153461

Rev: A

Page 1 of 1

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .006 - .001	.259	✓			
r .386	± .010	.386	✓			
.586	"	.586	✓			
1.337	"					can't measure
1.101	"	1.103	✓			
r .125	#25	.125				
2.715	"	2.714	✓			

Measured by: SL
Date: 06-03-24

Audited by:	En
Date:	06/03/24

Prototype Approval.

Date: _____

Rev	Date	Change
A		New Issue

Revised by KJ/RF Approved _____